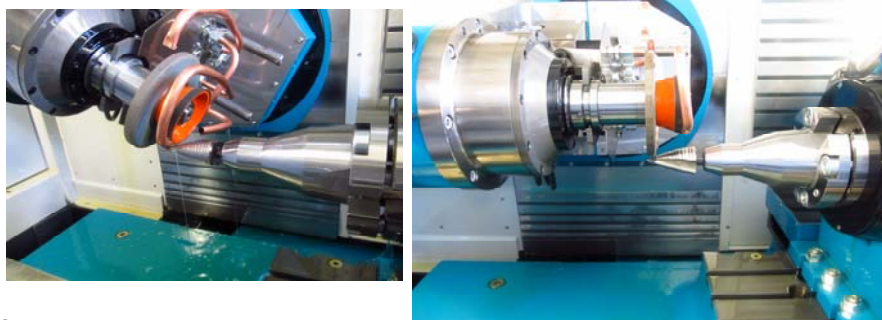
















Sheet Metal Stepdrill Ø6.7 - Ø35.3

A06-200

The pre-milled shear-flute of the sheet metal stepdrill is ground in 5 passes of each 0.3 mm increment plus 2 additional fast sparkout passes. The vitrified wheel for fluting has to be dressed after each 10 to 20 pieces. The O.D. is ground step by step in one pass (overmeasure around 0.1 to 0.3 mm).



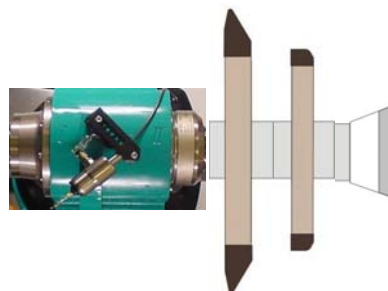
1. Cycletime for Production

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| Workpiece: Ø 6.7 - 35.3 mm, Z 2, Length 54 mm, Shear angle 12° Material HSS | | | | | | | | |
| Operations |  |  |  |  |  |  |  |  |
| Feed [mm/Min] | 2000 | 900 | 100 | 100 | 100 | 2000 | 150 | 9000 |
| Power [kW] | | 8 | 2 | 1 | 1 | 2 | 2 | 1 |
| Cutting speed [m/s] | | 40 | 32 | 32 | 32 | 45 | 32 | |
| Used wheels | |  |  |  |  |  |  | |
| Grinding time [s] | 15 | 256 | 40 | 18 | 18 | 145 | 41 | 16 |
| Total cycle time | 9 Min 9 | | | | | | | |

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

| | |
|---|-------------------|
| 1 | DXF Ø200 B20 C120 |
| 2 | 1A1-1V1 Ø125 B126 |
| 3 | 11V9 Ø75 B126 |



1 2 3

3. Machine and Software Requirements

| | | | |
|-----------------------|----------------------------------|-----------|--------------------------------|
| Machines: | 5 axes CNC grinders : GEMINI DMR | Coolant: | Synthetic Oil, pressure 16 bar |
| Control: | Fanuc 31i | Software: | Quinto 5 |
| Accessories: | Dressing | | |
| Responsible engineer: | OP. 3.5.12 | | |

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